

Date: Tuesday, 2/27/2007 1:00:01 PM
 User: Eric Charbonneau

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ADAPTER
Job Number	: 30976		
Estimate Number	: 12753		
P.O. Number	: <i>N/A</i>	Part Number	: D35739
This Issue	: 2/27/2007 S.O. No. : <i>N/A</i>	Drawing Number	: UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Drawing Revision	: U/R
Previous Run	: <i>N/A</i>	Material	: <i>N/A</i>
Written By	: <i>BE</i>	Due Date	: 3/6/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	3 Um: Each
Comment	: Est Rev:A New Issue 07-01-29 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B0500X02500	6061-T6 Bar .50" x 2.5"
-----	--------------------	-------------------------



Comment: Qty.: 0.3066 f(s)/Unit Total : 0.9198 f(s)
 6061-T6 Bar .50" x 2.5"
 Batch: *M103435*

*JML 07/02/28**3*

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW *3.500"*
 Cut blank *3.250"* long

*JML 07/02/28**3*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA679 and Dwg D3573

J.F/MR 07/02/28

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F/MR 07/02/28

5.0	QC8	SECOND CHECK ENGINEERING APPROVAL
-----	-----	---



Comment: SECOND CHECK

*UG 07-03-21**SA 07-03-01*

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

*FL/**07/03/01*

Date: Tuesday, 2/27/2007 1:00:01 PM
User: Eric Charbonneau

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADAPTER

Job Number: 30976

Part Number: D35739

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



M101601



③X

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M.H.

07/03/02

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAD

07/03/02

3

9.0

PACKAGING 1

PACKAGING RESOURCE #1



FOR ENGINEERING USE ONLY

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Rep'd 7/03/05

③

Russ took

pry 00064

07/03/05

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

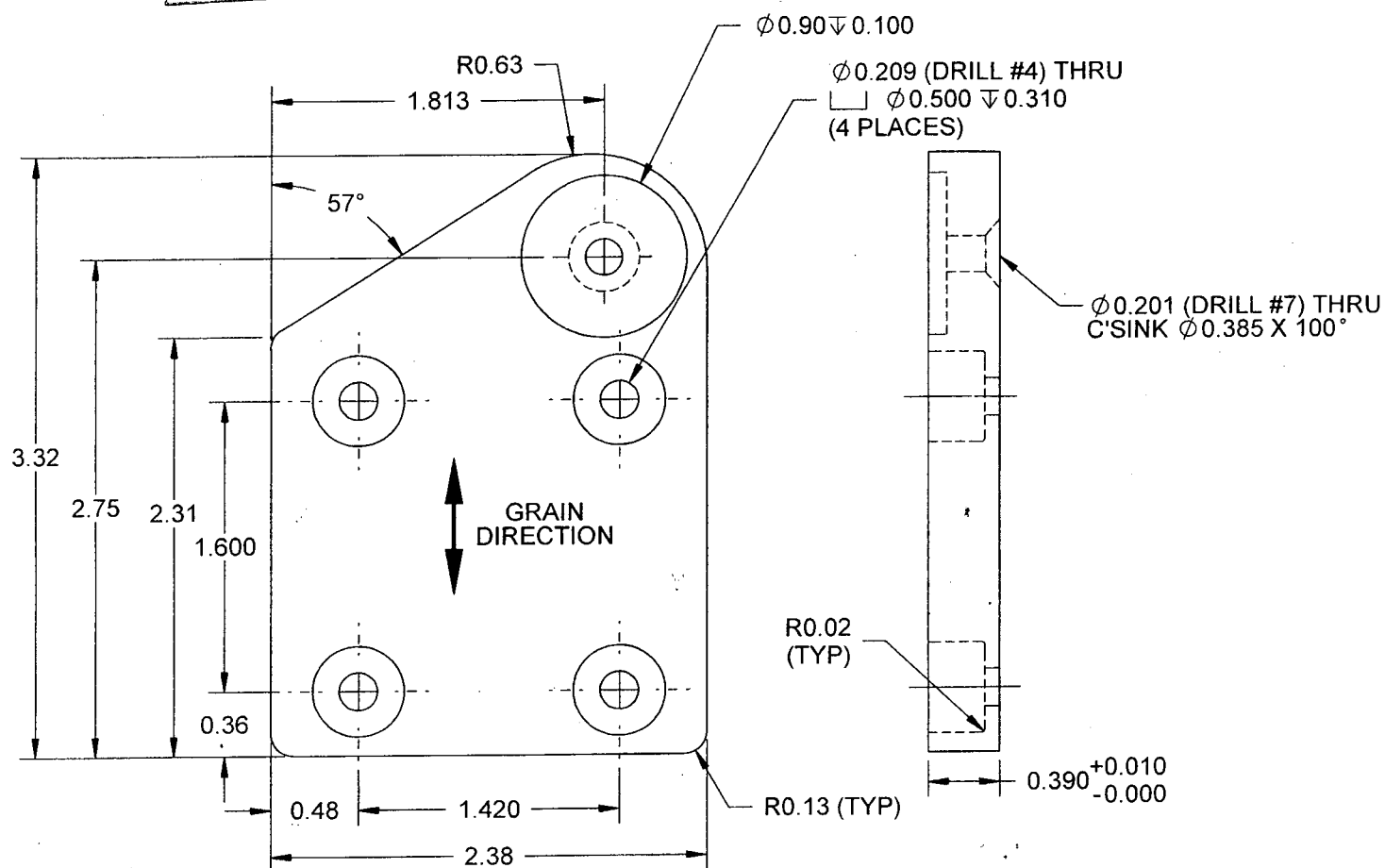
Job Completion



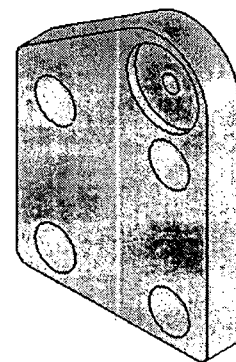
u 07-03-05

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3573	REV. A SHEET 4 OF 4
DATE 07.02.19		TITLE ADAPTER	SCALE 1:1

07-02-19 LE



D3573-7 ADAPTER (SHOWN)
(D3573-9 ADAPTER (OPPOSITE))



NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-7/-9" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD		Work Order: 30976
Description: Adapter		Part Number: D3573-9
Inspection Dwg: D3573 , Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R.63	$\pm .030"$	R.63"				
1.813	$\pm .010"$	1.813	✓			
57°		57°				
3.32	$\pm .030"$	3.32	✓			
2.75	$\pm .030"$	2.75	✓			
2.31	$\pm .030"$	2.31	✓			
1.600	$\pm .010"$	1.600				
.36	$\pm .030"$.36	✓			
.48	$\pm .030"$.48	✓			
1.420	$\pm .010"$	1.420	✓			
2.38	$\pm .030"$	2.377	✓			
R.13	$\pm .030"$.13	✓			
R.02	$\pm .030"$.02	✓			
.390	$\pm .010$ $\pm .000$.395"	✓			
Ø.201	$\pm .005"$ $\pm .001"$.202	✓			
Ø.385×100°	$\pm .010"$		✓			
Ø.209	$\pm .005"$ $\pm .001"$.210	✓			
Ø.90	$\pm .030$.898	✓			
.100	$\pm .010$.103	✓			
.500"	$\pm .010"$.495"	✓			

Measured by:	MS/J.F.
Date:	01/02/28

Audited by:	En
Date:	07/03/21

Prototype Approval:	LE
Date:	07.03.21

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	